









Work Order ID 55790

February 1, 2010 10:02:24 AM




Page 1

Item ID: D3825-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Rib Assembly (Basket End)
Start Date: 2/01/10 Start Qty: 6.00  Cust Item ID:
Required Date: 2/05/10 Req'd Qty: 6.00  Customer:
Reference:

Approvals: Process Plan:  Date: 10-2-01 Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3825	Rev A								

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- cut D3825-1 rib as per dwg D3825								
	2- drill hole (3/16") in D3825-1 using DT9438 jig and open to finish size as per dwg D3825								
	3- c'sink hole as per dwg								
	4- remove identification markings								
	5- deburr								
	6- weld D2327-3 spacer bushing and D3759-1 bushing as per dwg D3825 PD A/R S.S. Rod Batch: M109213								
	7- grind bushing weld flush where indicated on dwg D3825 PD								
	8- deburr if necessary PD								

SAD 10.02.03

PD 10.02.04 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3825-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket End)

Start Date: 2/01/10 Start Qty: 6.00



Cust Item ID:

Required Date: 2/05/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

lpc 10/02/04

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) 8/10/02/04



150

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

SAD 10-02-09



W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/05 *[Signature]*
ME
10-2-4

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Picklist Print

February 1, 2010 10:02:28 AM

Page 1

Work Order ID: 55790

Parent Item: D3825-041

Parent Item Name: Rib Assembly (Basket End)



Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Start Date: 2/01/10

Required Date: 2/05/10

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-3  Spacer Bushing		Manufactured	No			100	Each	45.0000	6.0000 			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 25

44274 4

44365 9

54135 12

Main Warehouse

WA 20

55167 20

PD 10.02.04 ④

PD 10.02.04 ②

D3759-1



Bushing

Manufactured No

100

Each

55.0000

6.0000


Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA 55

53442 2

54072 18

55093 35

PD 10.02.04

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Parent Item Name: Rib Assembly (Basket End)

Start Date: 2/01/10

Required Date: 2/05/10

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M304TS0.750W.065

Purchased

No

100

f

501.7940

13.4211



304 SQ Tube .75x.75x.065W



SAD 10-02-04

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

501.7939742

113082

0.00419

113245

0.00038421

113683

201.7894

113836

300

13.4211

Main Warehouse

WA

0.0000047

112398

0.0000047

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

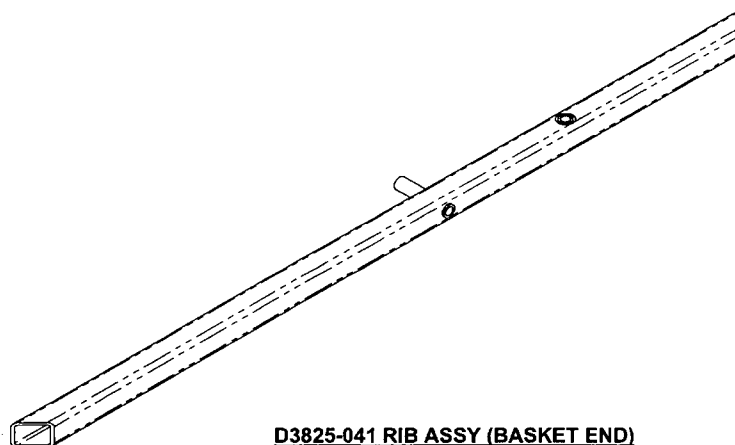
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NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
1	X	D3825-041	RIB ASSEMBLY (BASKET END)
2	1	D2327-3	SPACER BUSHING
3	1	D3759-1	BUSHING
4	1	D3825-1	RIB



D3825-041 RIB ASSY (BASKET END)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35790

10-2-01

RELEASED
08/11/18

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.22 lbs
 - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.23		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A
DRAWING NO. D3825	SHEET 1 OF 3	
TITLE RIB ASSY (BASKET END)	SCALE NTS	
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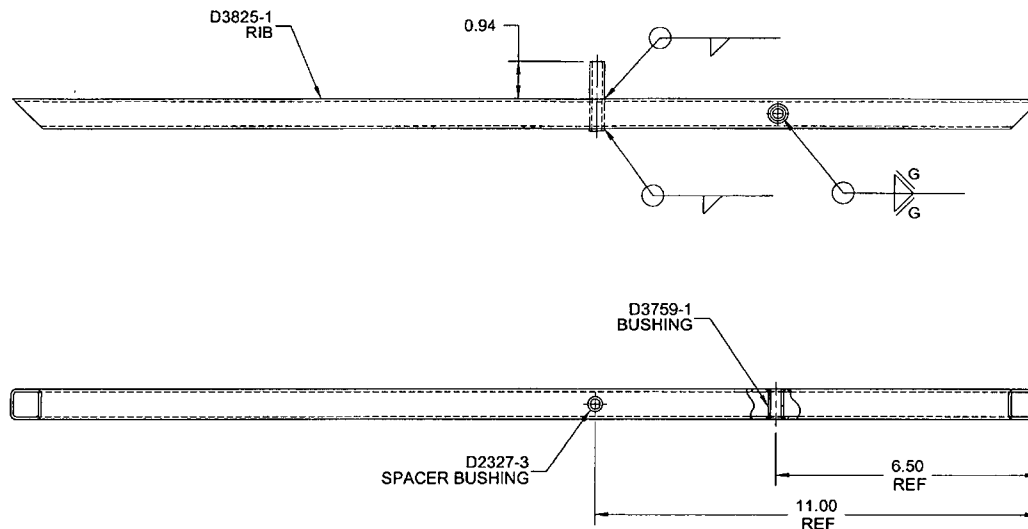
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D3825-041 RIB ASSY (BASKET END)

RELEASED
08/11/18 NW

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	MS	DRAWING NO. D3825	REV. A
MFG. APPR.		TITLE RIB ASSY (BASKET END)	SHEET 2 OF
APPROVED	WJ		SCALE
DE APPR.	WJ	NTS	
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W/O 55790

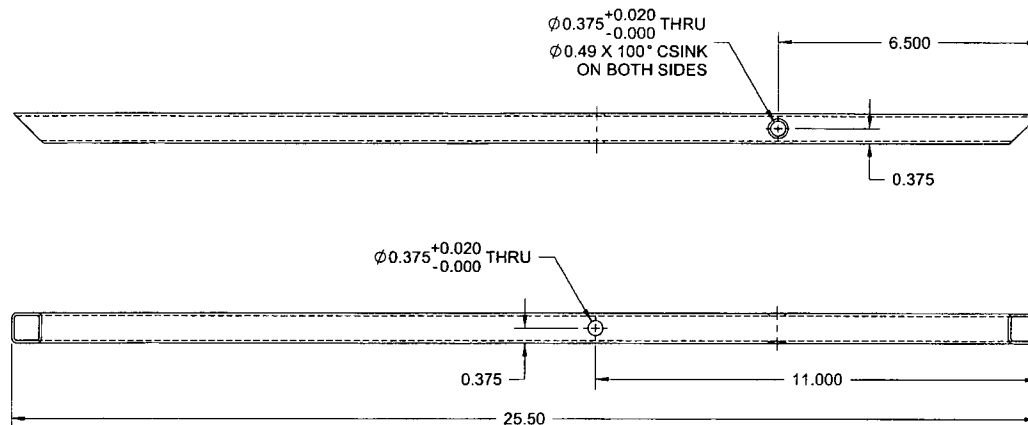
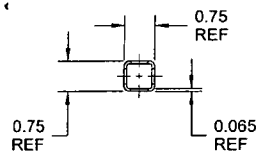
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D3825-1 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.18 lbs

RELEASED
08/11/13

WFO 55790

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3825	REV. A
MFG. APPR.		TITLE	SHEET 3 OF 3
APPROVED		RIB ASSY (BASKET END)	SCALE
DE APPR.			NTS
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